

WHAT IS CLAIMED IS:

1. A roll for feeding substrate material comprising:
5 a sheet roller configured to rotate about a first axis and having a circumference and a surface layer; and
a plurality of salient members disposed on said surface layer to extend along said first axis at intervals about said circumference, each of said plurality of salient members configured to cause a fold line to form across a
10 width of said substrate material substantially perpendicular to a direction of travel of said substrate material.
2. The roll of Claim 1, wherein said plurality of salient members
15 comprise a material selected from the group consisting of resins, metals and paper.
3. The roll of Claim 1, wherein each of said plurality of salient
members comprise a salient member having a substantially rectangular cross
20 section.
4. The roll of Claim 3, wherein at least one corner of said
rectangular cross sectional member is rounded.
5. The roll of Claim 4, wherein a radius of said at least one
25 rounded corner is equal to between about half of the thickness of the salient member to about twice the thickness of the salient member.
6. The roll of Claim 4, wherein a radius of said at least one
rounded corner is equal to between about 0.05 mm and about 2 mm.
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7. The roll of Claim 1, wherein each of said plurality of salient
members comprise a salient member having a substantially circular cross
section.

8. A method comprising:

feeding a sheet of substrate material into a sheet roller configured to rotate about a first axis and having a circumference and a surface layer; and

5 forming a fold line across a width of said sheet of substrate material substantially perpendicular to a direction of travel of said substrate material as said sheet of substrate material contacts at least a portion of said sheet roller.

9. The method of Claim 8, wherein said sheet roller comprises a plurality of salient members disposed on said surface layer to extend along said first axis at intervals about said circumference, each of said plurality of salient members configured to contact said sheet of substrate material to cause said formation of a fold line across a width of said substrate material substantially perpendicular to a direction of travel of said substrate material.

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10. The method of Claim 9, wherein said plurality of salient members comprise a material selected from the group consisting of resins, metals and paper.

20 11. The method of Claim 9, wherein each of said plurality of salient members comprise a salient member having a substantially rectangular cross section.

25 12. The method of Claim 11, wherein at least one corner of said rectangular cross sectional salient member is rounded.

13. The method of Claim 12, wherein a radius of said at least one rounded corner is equal to between about half of the thickness of the salient member to twice the thickness of the salient member..

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14. The method of Claim 12, wherein a radius of said at least one rounded corner is equal to between about 0.05 mm and about 2 mm.

15. The method of Claim 9, wherein each of said plurality of salient members comprise a salient member having a substantially circular cross section.

5 16. A roll for feeding substrate material comprising:
a sheet roller configured to rotate about a first axis and having a circumference and a surface layer; and
means for forming a fold line across a width of said substrate material substantially perpendicular to a direction of travel of said substrate material.

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17. The roll of Claim 16, wherein said means comprises a plurality of salient members disposed on said surface layer to extend along said first axis at intervals about said circumference.

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18. The roll of Claim 17, wherein said plurality of salient members comprise a material selected from the group consisting of resins, metals and paper.

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19. The roll of Claim 17, wherein each of said plurality of salient members comprise a salient member having a substantially rectangular cross section, wherein at least one corner of said rectangular cross sectional member is rounded.

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20. The roll of Claim 19, wherein a radius of said at least one rounded corner is equal to between about 0.05 mm and about 2 mm.